

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021935**Date Inspected:** 06-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

BAY 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding processes.

ZPMC QC is identified as Zhan Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Side Plate

PCMK: SEG3019AW

Weld Number: 100

Welder: 054013

WPS-B-P-2212-TC-U4b-FCM-1

Component: Side Plate

PCMK: SEG3019AW

Weld Number: 100

Welder: 044779

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-P-2212-TC-U4b-FCM-1

Component: Side Plate

PCMK: SEG3019AW

Weld Number: 100

Welder: 050969

WPS-B-P-2212-TC-U4b-FCM-1

Component: Side Plate

PCMK: SEG3019AW

Weld Number: 100

Welder: 215553

WPS-B-P-2212-TC-U4b-FCM-1

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08473 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3007G-123, 131, 200

BAY 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding processes.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Steel Barrier

PCMK: E5-SB25A-001

Weld Number: 001~012

Welder: 053753

WPS-B-P-2113

Component: Steel Barrier

PCMK: W2-SB26-001

Weld Number: 077, 078

Welder: 201074

WPS-B-T-2133

Component: Steel Barrier

PCMK: E5-SB25C-001

Weld Number: 048, 049

Welder: 201905

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-B-T-2113

Component: Steel Barrier

PCMK: E2-SB24C-001

Weld Number: 075~078

Welder: 201889

WPS-B-T-2132

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
